

Date: Thursday, 5/4/2006 11:19:32 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR SUPPORT
Job Number : 26989	
Estimate Number : 12309	
P.O. Number : N/A	Part Number : D3471043
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3471 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 26611	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 5/28/2006
Checked & Approved By : <u>06.05.05</u>	Qty: <u>4</u> Um: Each
Comment : est rev A 06.03.02 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS3584216	CLAMP
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
pick:

Qty	Part number	Description	Batch
1	MS35842-16	CLAMP	<u>M10076</u>

FF 06.05.15

4

2.0	MS20427M44	RIVET
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)
pick:

Qty	Part number	Description	Batch
3	MS20427M4-4	Rivet	<u>M100393</u>

FF 06.05.15

4

3.0	D34713	SUPPORT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
pick:

Qty	Part number	Description	Batch
1	D3471-3	Support	<u>B26126</u>

FF 06.05.15

4

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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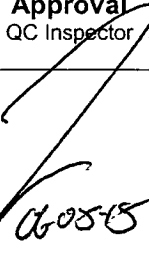
Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

FF 06.05.15

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.05.15	4	1 Bracket D3471-3 2 clamps MS35842-16 bit ovalized hole in bracket during transfer drilling. At into S.S.		scrap 2 Destroy scrap 3 Destroy	FF 06.05.15 FF 06.05.15			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/05/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 11:19:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26989

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



160516 (4)

Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SS 06/05/17 (4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/19 (4)

Job Completion



U 06-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

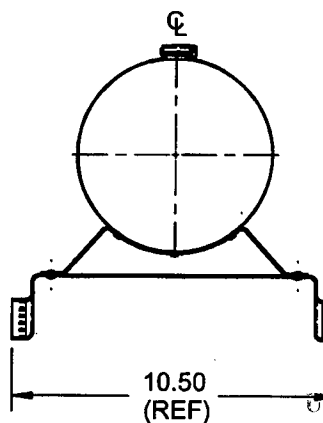
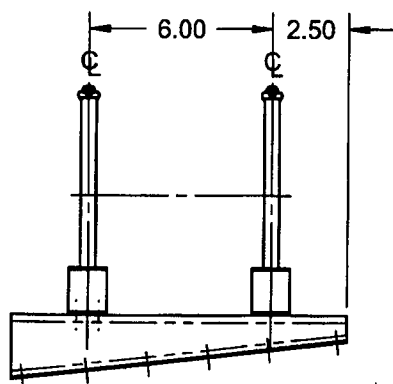
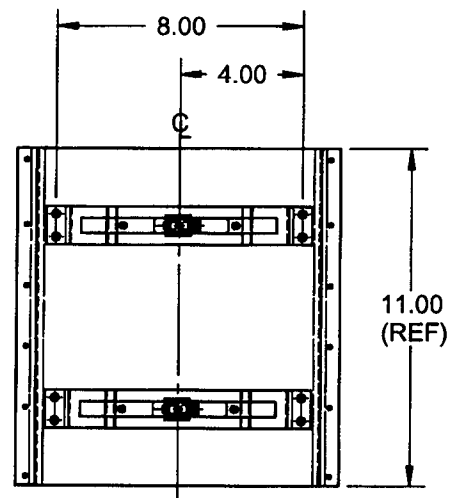
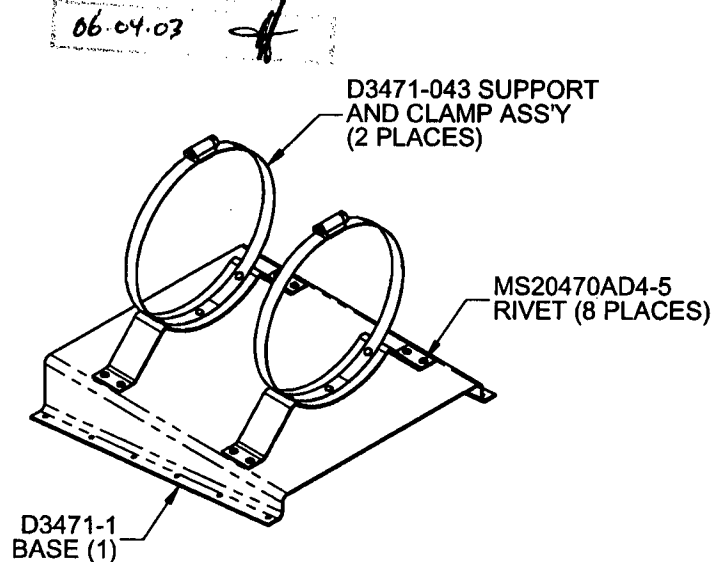
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	



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NO. 26989

D3471-041 BLOWER MOTOR SUPPORT

NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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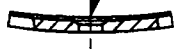
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CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:3

06.04.03

LOCATE AND TRANSFER DRILL
#30 ($\varnothing 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\varnothing 0.230 \times 100^\circ$
(3 PLACES)

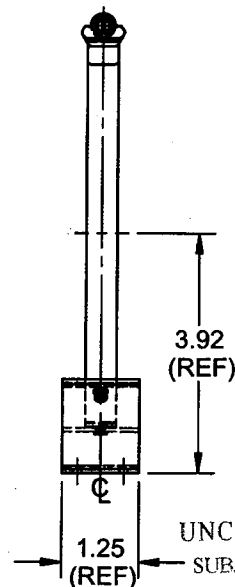
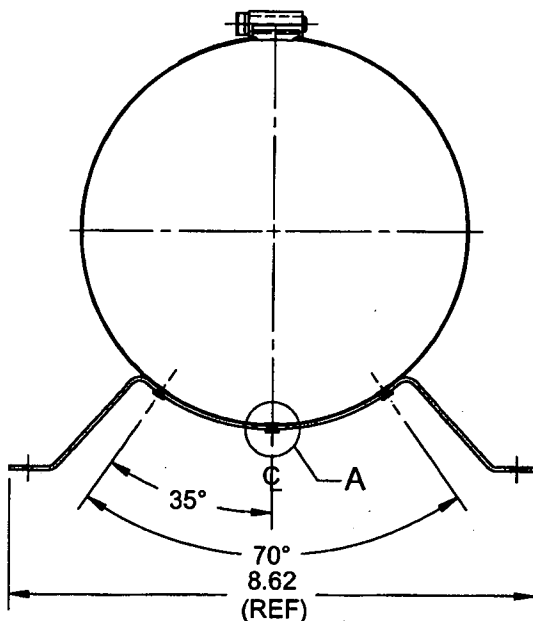


DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1

MS20427M4-4 RIVET
(3 PLACES)

MS35842-16
CLAMP

D3471-3
SUPPORT



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D3471-043 SUPPORT & CLAMP ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

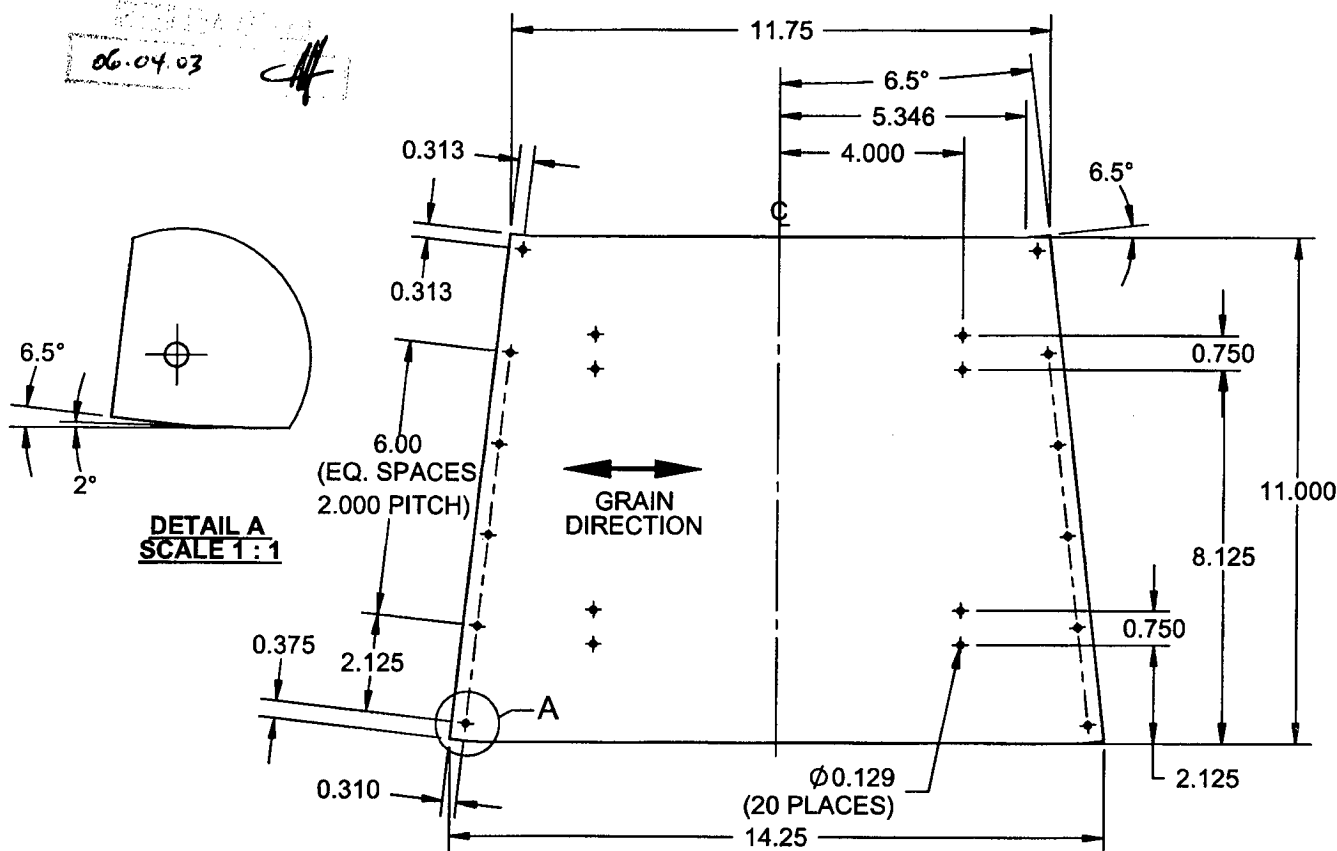
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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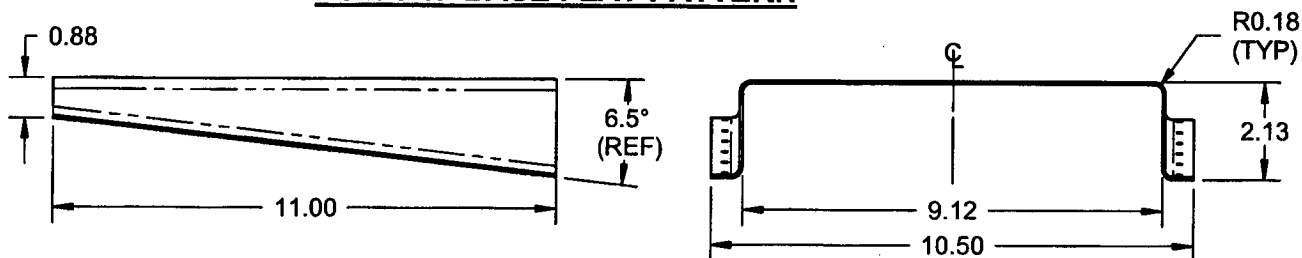
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

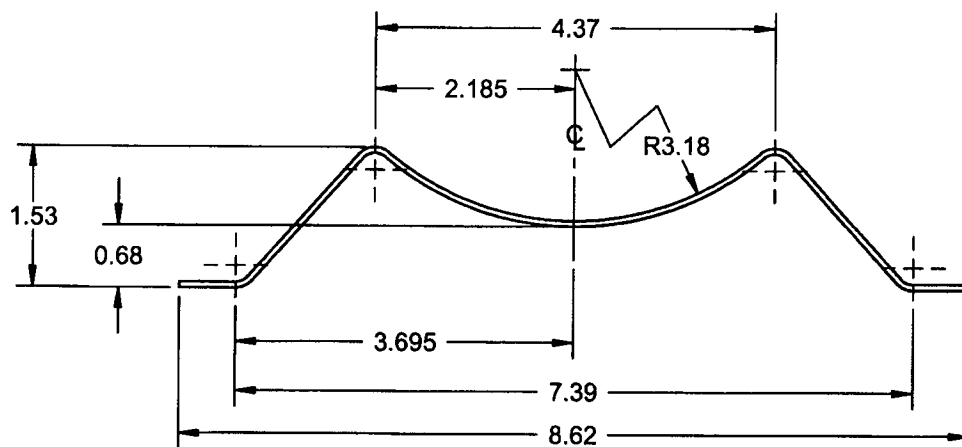
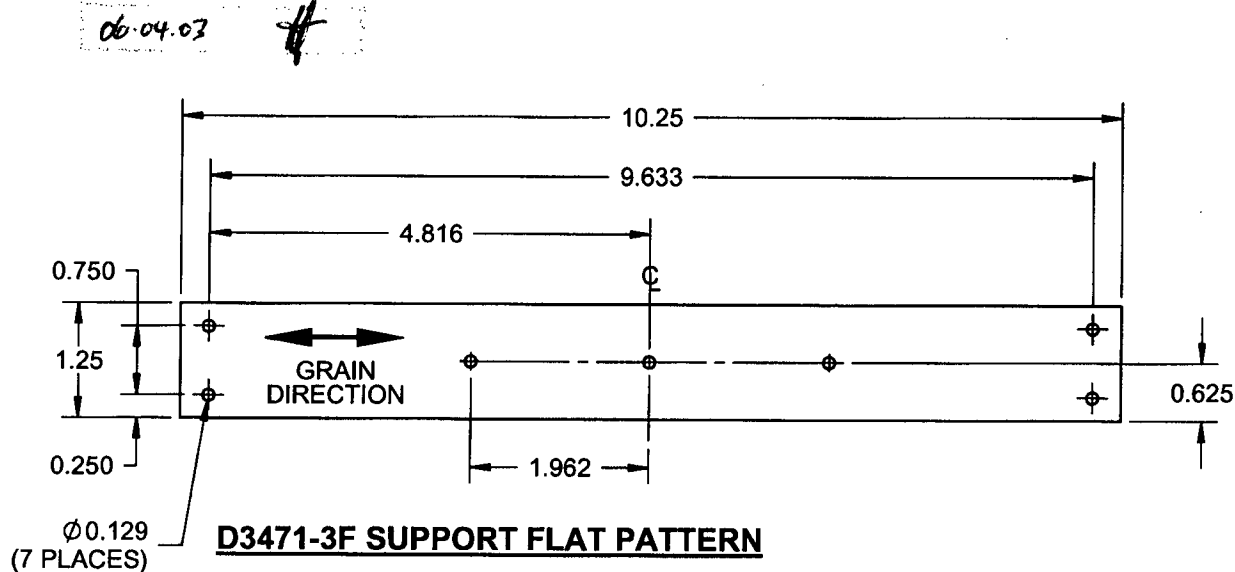
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 4 OF 5 SCALE 1:2



D3471-3 SUPPORT BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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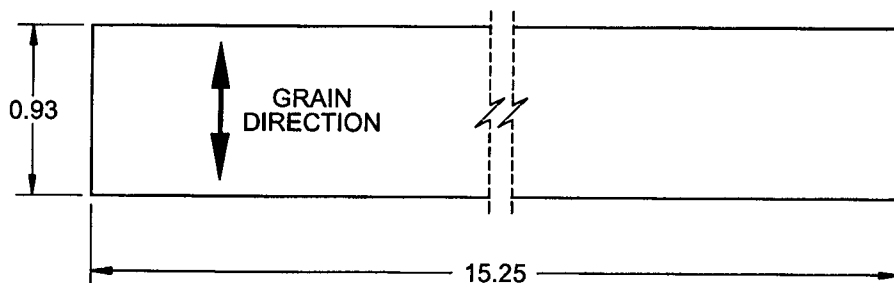
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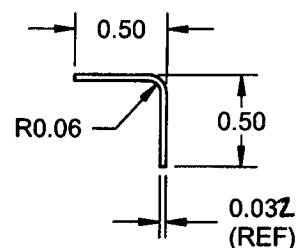


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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:1	

06.04.03 *A*



D3471-5F STIFFENER FLAT PATTERN



**D3471-5 STIFFENER
BENDING DETAIL**

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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